

Work Order ID 70687-2

Monday, June 13, 2011 1:32:22 PM



Page 1

Item ID: D3537-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearpad

Start Date: 6/13/2011 Start Qty: 50.00



Cust Item ID:

Required Date: 6/17/2011 Req'd Qty: 50.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date: 6/13/11

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3537

Rev C

100



Waterjet

FLOW WATER JET

0.00

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3537 Dwg Rev: C Prog Rev: C 2-Deburr if necessary

B11-615

110



QC

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

Quality Control

B11-615

120



QC

QC8- Inspect parts - second check

0.00

Memo

0.00

Quality Control

Sulx15

counters
x60

Work Order ID 70687

Monday, June 13, 2011 1:32:22 PM

Page 2

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Cust Item ID:

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Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Brake NC

Brake NC

NC BRAKE

Memo

1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326. 2-Identify as D3537-1

0.00

0.00

140



Large Fab

Large Fab

Large Fab

Memo

Qty Description Batch A/R 2059B Hardcoat
M118453 1-Weld as per Dwg D3537 using Jig DT 8210. 2-Remove any weld that penetrated through Wearpad if necessary

0.00

0.00

150



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

Memo

0.00

0.00

60

11-8-23

X18

8/6/02/24

X18

Work Order ID 70687

Monday, June 13, 2011 1:32:22 PM



Page 3

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Start Date: 6/13/2011 Start Qty: 50.00



Cust Item ID:

Required Date: 6/17/2011 Req'd Qty: 50.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00

5 ulog/zy

0.00

(418)

QC

Memo

Quality Control

170

Grey Sandtex(Ref:4.3.5.6) per QS1005 4.3

0.00

Powdercoat

Memo

Powder Coating

START TIME:

OVEN TEMPERATURE:

M 117338

3200F

9:45

0.00

FINISH TIME:

10:15

18x Ø M-L 11/08/25

180

QC3- Inspect Part Finish

0.00

QC

Memo

Quality Control

18 BR 11-8-25.

Work Order ID 70687

Monday, June 13, 2011 1:32:22 PM



Page 4

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Start Date: 6/13/2011 Start Qty: 50.00



Cust Item ID:

Required Date: 6/17/2011 Req'd Qty: 50.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

Identify as per dwg & Stock Location:

FR/L

0.00



Packaging

Memo

0.00

Packaging

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

18 BR 11-8-25

11/8/25

CL11/08/25

Picklist Print

Monday, June 13, 2011 1:32:28 PM

Page 1

Work Order ID: 70687



Parent Item: D3537-1



Parent Item Name: Wearpad

Start Date: 6/13/2011

Required Date: 6/17/2011

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S16GA

Purchased

No

100

sf

119.1000

0.106

5.578947



Bill-675

304/316 Sheet .063

Location

Loc Qty

Loc Code

MAT020

119.1

117275

4.3

117653

114.8

117653

UNCONTROLLED COPY

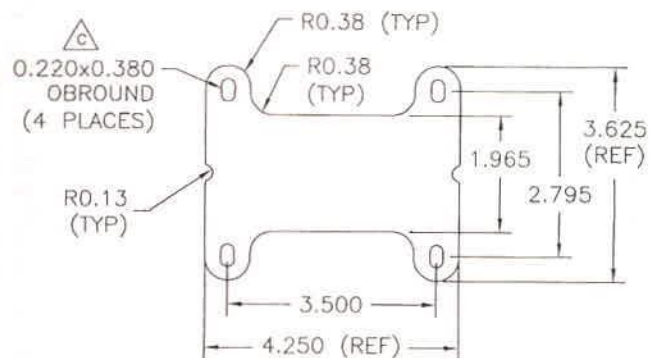
SUBJECT TO AMENDMENT

WITHOUT NOTICE

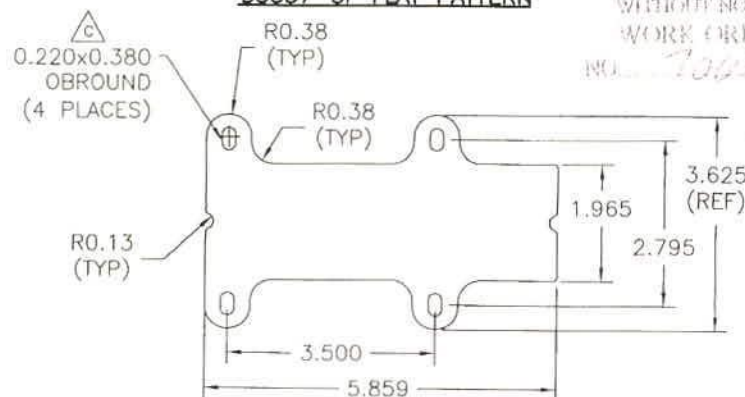
WORK ORDER

NO. 70087

D3537-1F FLAT PATTERN

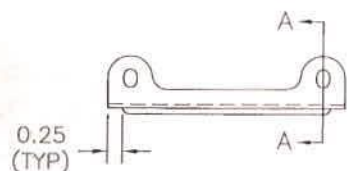


D3537-3F FLAT PATTERN



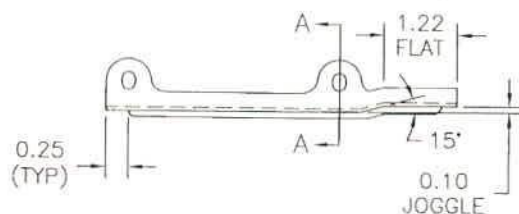
D3537-1 LONGITUDINAL BEND

(MADE FROM D3537-1F)



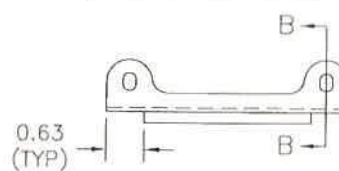
D3537-3 LONGITUDINAL BEND

(MADE FROM D3537-3F)

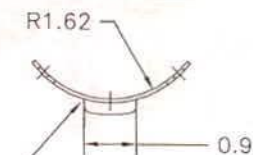


D3537-5 LONGITUDINAL BEND

(MADE FROM D3537-1F)

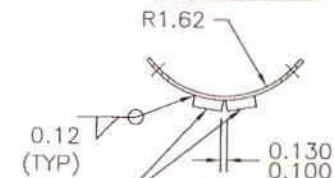


SECTION A-A



APPLY 2 LAYERS OF 2059B HARDCOAT WELDS TO WITHIN 0.25 OF WEARPAD ENDS 0.188 TO 0.250 THICK

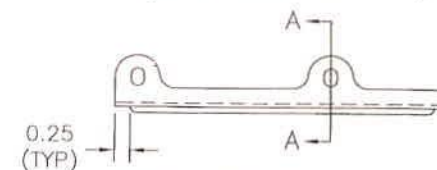
SECTION B-B



D2941-300 REMOVE POWDER COAT FROM THESE SURFACES

D3537-7 LONGITUDINAL BEND

(MADE FROM D3537-3F)



D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK) (REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	CB	DRAWN BY PH
CHECKED	4	APPROVED 4
DATE	07.04.13	DRAWING NO. D3537
		TITLE WEARPAD
		REV. C SHEET 1 OF 1
		SCALE 1:2

DART DART AEROSPACE USA, INC.
 PORT HADLOCK, MA

RELEASED
 07.05.03 PM
 PER EUN 962